1 5/15

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DART AEROSPACE LTD	Work Order:	224933
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qtv:	3 26 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A	111	Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	4	05.02.21	
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 (Bag Bluefiles separately)	DH.	05.04.05	3
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M 1592 L	me	osloslau	64
4	MV	Inspect material for defects or damage prior to machining	me	achalous	64
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	The	35/03/11	14
6	QC2	Inspect parts as they come off the CNC machine	me	05/03/11	14
7	MV	Deburr	gre	05/03/11	14
8	QC8 & 5	Second inspection	to	05/03/11	14
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) Qty Part Number Description Batch 6 D2182B050 Rubber Cushion B30437/B 12 D2274 Radius Block B30437/B 2 D2432F 24" Bearpaw B30437/B 6 D2438 Clamp B3159/A 12 D2529 Washer B3158/A 6 D2732-050 Rubber Cushion B304/33/A 12 AN4-15A Bolt M1532/A 12 AN4-17A Bolt M1532/A 24 AN960JD416 Washer M1459/A 12 MS21042L4 Nut (or -4) M15020 1 Paperwork package from Step 2	B22	140/B21 5/B218 1505	46
10	QC4	Inspect Kit for 100% Completeness on the W/O	- m	05/03/24	3
11	PK PK	Identify and pack for shipping as per PPP K10008	80	05/03/28	3
12	AC		CX	05/03/28	3
13	DC	Cost / part 16 8.15 Close W/OZ Z 9, 7/ Inspect Level 21		05.03.29	3

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
Н	02.08.15	Added D427-659 to Step 2	KJ	
Ī	03.02.21	Reformat; Incorporated D2432F	KJ/RF	J
J	04.02.17	Blank size changed on Step 3	KJ/JLM	-#-

BR 05-03-30 KJ/JLI

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PART AEROSPACE LTD	Work Order:	224936
Description: Bearpaw	Part Number:	D2432F
Inspection Dwg: D2432 Rev: F3		D2432F
1, 5, 52, 102		Page 1 of 1

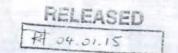
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Ins Draw	pection Sheet ving Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Α	0.063 x 45°	+0.030/-0.010	0.060	/		Vem	
В	5.500	+/-0.030	5.500				
С	0.200	+/-0.030	0.203	_		Ven	
D	0.25 x 45°	+/-0.030	0.230x45°	_		Ven	
Е	R0.250	+/-0.030	RO.250			Ven R-G	
F	0.250	+/-0.010	0.254				
G	0.625	+/-0.030	0.612	_		Ven	
Н	0.375	+/-0.010	0.382	_	84	Ven	199
1	0.950	+0.030/0.010	0.960			Vem	70
J	19.000	+/-0.030	19.000			Ven	
K	3.14	+/-0.030	3.124			M-Tape	
L	3.28	+/-0.030	3.270			Ven	
M	Ø0.260	+0.005/-0.000	80.260			Vem	
Ν	Ø0.93	+/-0.030	Ø.929			Vem	
0	0.30	+0.030/-0.000	0.305			Vem	
Р	23.750	+/-0.030	23.750			Ven	
Q	7.375	+/-0.030	7.375			M-Tage	
R	4.250	+/-0.010	4.250	_	-	Her M-Tax	7
S	2.000	+/-0.030	2.000			M-Toyal	
T	9.000	+/-0.010	9.000			Ven	
U	9.000	+/-0.010	7.000			19-taxe	
V	0.375	+/-0.010	0.380			ri-lope	
			0.280	Alexander		Ven	

Measured by:		Audited by: 5A		Prototype Approval: N/A	
Date:	05/03/07	Date:	6503.07	Date:	ıla.
			- 3		NH

Rev	Date	Change			
	A 04.01.09		0/	Revised by	Approved
	04.01.09	INEW ISSUE	Plo K10008/0206-559-015	KJ/RF	-#



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